

Date: Thursday, 4/12/2007 8:45:26 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 31726
 Estimate Number : 12711
 P.O. Number : N/A Part Number : D35373
 This Issue : 4/12/2007 S.O. No. : N/A Drawing Number : D3537 REV A B C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A B R# 07.04.26
 Previous Run : 30758 Material : N/A
 Written By : Due Date : 4/16/2007 Qty: 10 Um: Each
 Checked & Approved By : [Signature] 07.04.12
 Comment : Est Rev: A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.1512 sf(s)/Unit Total: 1.5120 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: ml 01 04 26 (10)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: B ml 01 04 26 (10)

Prog Rev: B

2-Deburr if necessary > ml 07/04/30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 01 04 26



Comment: INSPECT PARTS AS THEY COME OFF MACHINE (10)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 07/04/26 (10)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3

Form Joggle as per Dwg D3537 on brake using Jig DT8158

SRB 07/04/30 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Q Date: 07/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:45:26 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

07/04/30 (10)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M102 258

FC 07/04/30 (10)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/04/30 (10)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/30 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101 601

07-05-04 (10)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H 07/05/04 (10X)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

M-H 07/05/04 (10X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/04 (10)

Job Completion



07/05/04 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

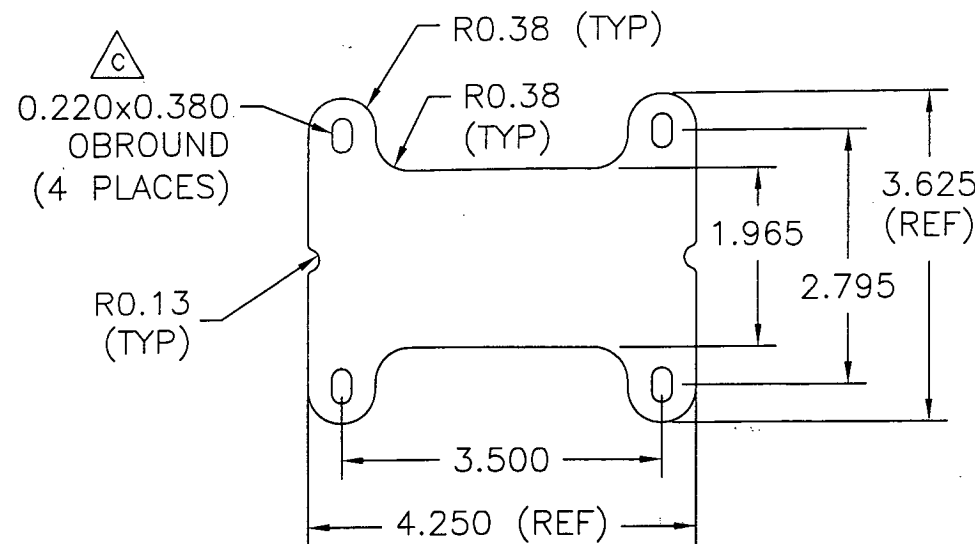
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

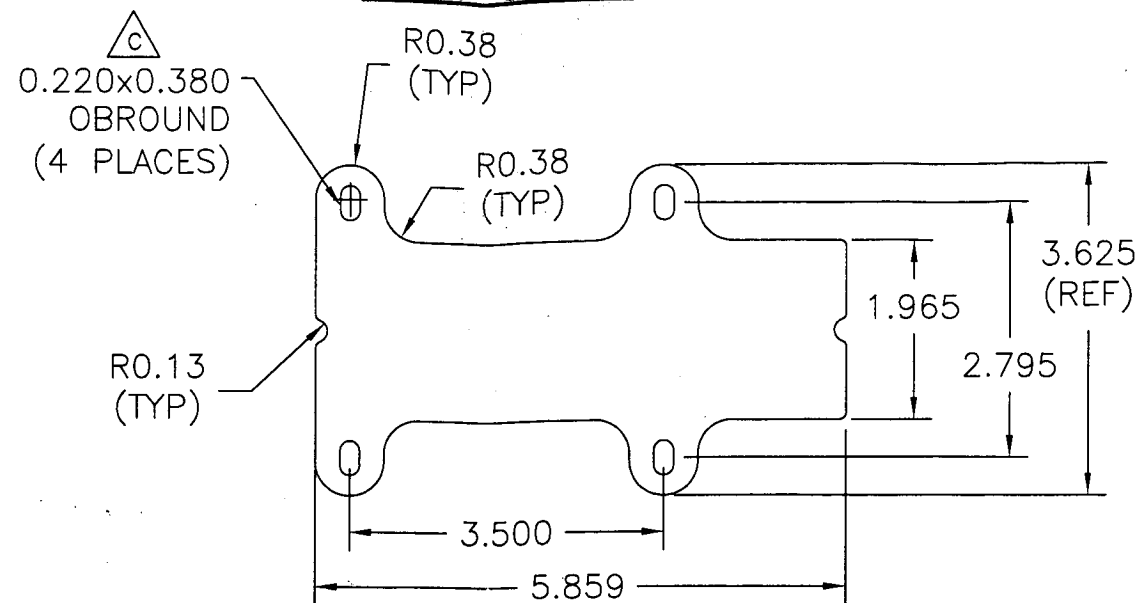
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

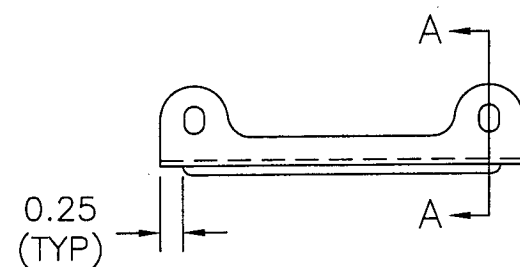
D3537-1F FLAT PATTERN



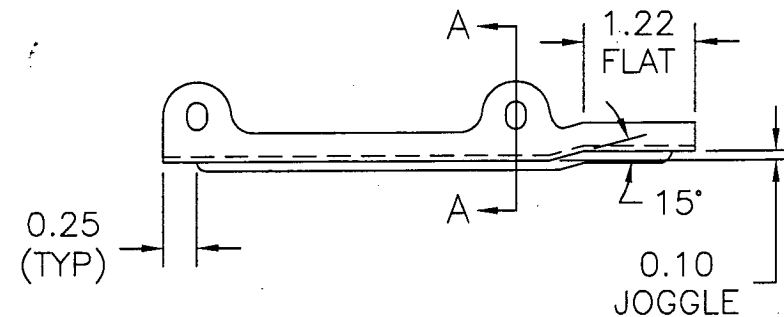
D3537-3F FLAT PATTERN



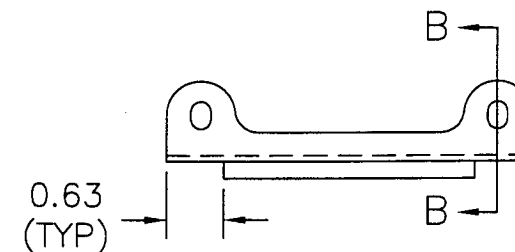
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



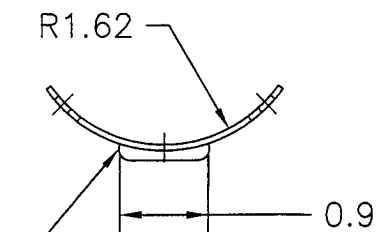
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

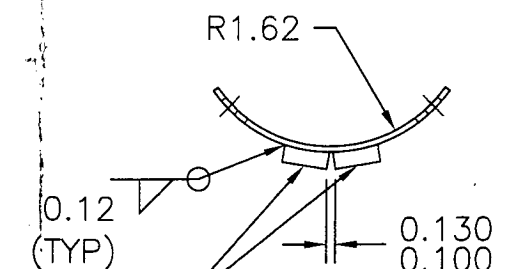


SECTION A-A



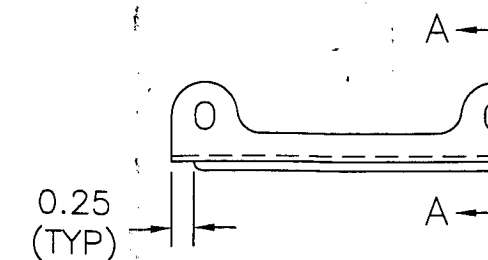
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO.

D3537

TITLE

WEARPAD

07.04.28

DART AEROSPACE LTD		Work Order: 31726
Description: <u>Wearpad</u>		Part Number: <u>D3537-3</u>
Inspection Dwg: <u>D3537</u> Rev: <u>B C</u> <u>02.04.07</u>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.625	+/- 0.010	3.624	✓		vern	
B 2.795	+/- 0.010	2.795	✓		vern	
C 1.965	+/- 0.010	1.968	✓		vern	
D 3.500	+/- 0.010	3.504	✓		vern	
E 5.859	+/- 0.010	5.866	✓		vern	
F 0.220x0.380	+/- 0.010	0.217x0.380	✓		vern	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <u>ml. ml</u>	Audited by: <u>[Signature]</u>	Prototype Approval:	N/A
Date: <u>07/04/26</u>	Date: <u>07/04/26</u>	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

[Signature]